

Work Order ID 128847

128847

Page 1

Tuesday, January 27, 2015 7:49:40 AM

Item ID: D3179-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Litter Tie Down (Non-Locking)
 Start Date: 1/27/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/27/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 1501-29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3179	Rev D								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blanks: 12.150" long

4 0 15/02/11

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: D 2-
 Deburr per dwg D3179-1

15/02/11

DAS
14
9-89

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

4 0 15/02/11

DAS
14
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128847***128847***

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Tuesday, January 27, 2015 7:49:40 AM

Item ID: D3179-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Tie Down (Non-Locking)

Start Date: 1/27/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/27/15

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

4 15/02/13

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

4 15-2-23 1/10/14

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

4. 15-2-24. 0.25 0.34 0.89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D3179-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Litter Tie Down (Non-Locking)
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M 128808</i> Memo START TIME: <i>11:00</i> OVER TEMPERATURE: <i>3:20</i> FINISH TIME: <i>11:30</i>	0.00 0.00				<i>H. d</i>	<i>15-2-24</i>	<i>DAS 34 9-89</i>	
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(4)</i>		<i>DAS 38 9-89</i>	<i>FEB 24 2015</i>
180 *180* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3179 <i>Drill Hole #1</i>	0.00 0.00				<i>4x</i>	<i>15/2/24</i>	<i>DAS 36 9-89</i>	<i>15.02.25</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128847

Tuesday, January 27, 2015 7:49:40 AM

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Page 4

Item ID: D3179-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Litter Tie Down (Non-Locking)
Start Date: 1/27/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/27/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00				<u>4</u>			DAS 38 9-89
190									
QC	Memo	0.00							
Quality Control									FEB 25 2015
200	Identify as per dwg & Stock Location: <u>Stamps</u>	0.00				<u>4</u>			DAS
200									05
Packaging	Memo	0.00							9-89
Packaging									FEB 26 2015
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									<u>MCS 15-02-26</u> <u>15-2-26</u>

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, January 27, 2015 7:49:39 AM

Page 1

Work Order ID: 128847

128847

Parent Item: D3179-041

D3179-041

Parent Item Name: Litter Tie Down (Non-Locking)

Start Date: 1/27/15

Required Date: 1/27/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
IPP Rev:B Added Powder Coat 07-07-04 JLM
AS PER REV D JLM 13-05-24 VERIFIED BY:DD
IPP Rev:C 08-12-10 add part list DD verified by:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2372 *D2372* Quick Release		Manufactured	No			180	Each	5.0000	2	8		15/02/24	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
				124469				5					
D2444 *D2444* Pip Pin Assembly		Manufactured	No			180	Each	6.0000	1	4		15/02/24	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
				123487				4					
				124412				2					
D6201 *D6201* "T" Extrusion		Manufactured	No			180	f	21.0620	1.0125	5		15/02/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT028				21.062					
				113608				1.062					
				124165				20					

B128516 (8x)

B128939 (4x)

5,59'

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Parent Item: D3179-041

D3179-041

Parent Item Name: Litter Tie Down (Non-Locking)

Start Date: 1/27/15

Required Date: 1/27/15

Start Qty: 4.00

Required Qty: 4.00

MS21042L3 Purchased No

180 Each 2,639.000 1 4

MS21042L3

Nut

**

15/02/24 DAS 36 9-89

Location Loc Qty Loc Code

FP001 420
M130922 420
ST305 2216
M130799 11
M131264 1205
M131317 1000
ST307 3
123900 3

MS27039-1-13 Purchased No

180 Each 773.0000 1 4

MS27039-1-13

Screw

**

M131317
42
15/02/24 DAS 36 9-89

Location Loc Qty Loc Code

GA 133
124326 133
ST273A 300
124326 300
ST285 340
125654 340

NAS1149D0332J Purchased No

100 Each 1,752.000 3 12

NAS1149D0332.J

Washer

**

15/02/24 DAS 36 9-89

Location Loc Qty Loc Code

CA 14
m129682 14
ST269 1738
m130325 1738

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Shop Packet Print

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order: 128847
Description: Fwd Litter Tie Down Bracket		Part Number: D3179-1
Inspection Dwg: D3179	Rev: D	Page 1 of 1

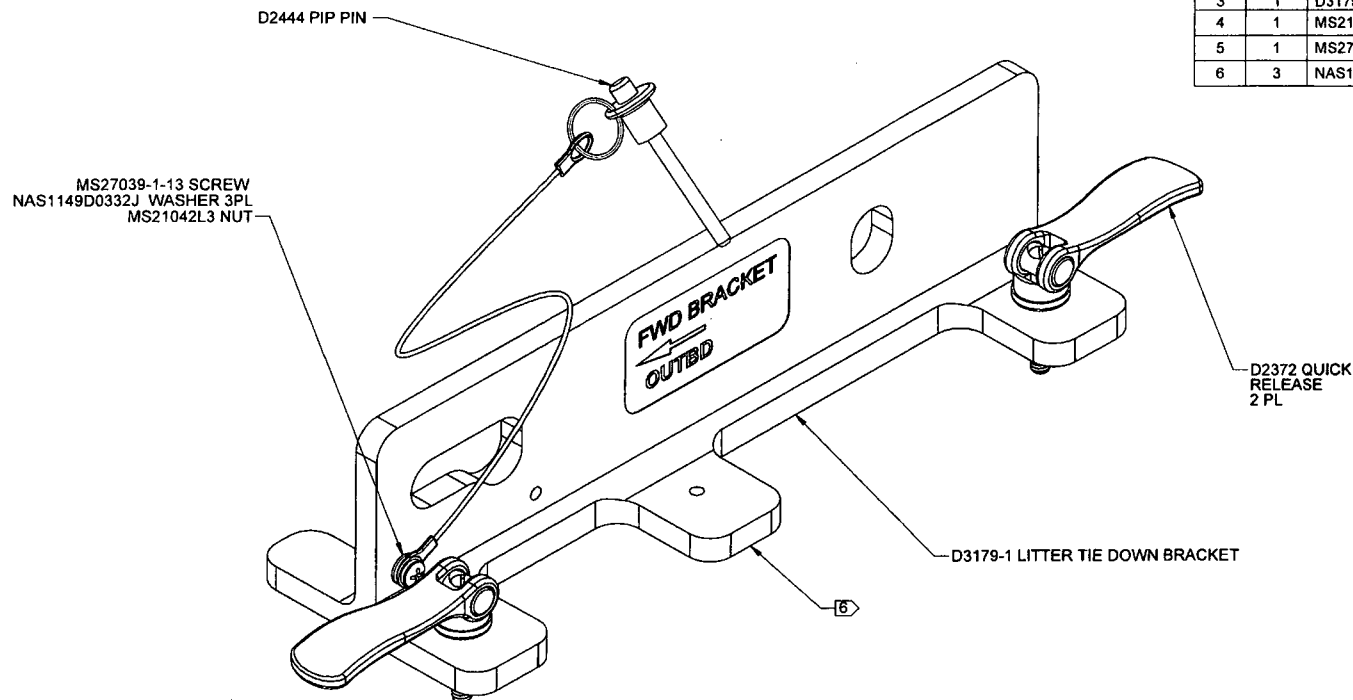
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.000	✓		Vern	ML-06
Ø0.242	+0.005/-0.001	Ø0.243	✓		"	
R0.40	+/-0.030	R.400	✓		R-6	
Ø0.375 .375	+/-0.010	.375	✓		Vern	ML-06
Ø0.191	+0.005/-0.001	Ø0.194	✓		"	
1.00	+/-0.030	1.000	✓		"	
1.70	+/-0.030	1.700	✓		"	
4.00	+/-0.030	4.000	✓		"	
1.50	+/-0.030	1.500	✓		"	
0.750	+/-0.010	.750	✓		"	
1.50	+/-0.030	1.500	✓		"	
10.500	+/-0.010	10.500	✓		M-tape	ML-08
4.250	+/-0.010	4.250	✓		Vern	ML-06
0.750	+/-0.010	.750	✓		"	
1.000	+/-0.010	1.000	✓		"	
12.00	+/-0.030	12.000	✓		"	
1.00	+/-0.030	1.000	✓		"	
8.00	+/-0.030	8.000	✓		"	
Ø0.191	+0.005/-0.001	Ø0.193	✓		"	
R0.37	+/-0.030	R.370	✓		R-6	
1.875	+/-0.010	1.870	✓		Vern	ML-06
0.375	+/-0.010	.374	✓		"	
2.125	+/-0.010	2.122	✓		"	
1.250	+/-0.010	1.250	✓		"	
1.00	+/-0.030	.994	✓		"	
3.31	+/-0.030	3.312	✓		"	

Measured by: [Signature] DAS 14	Audited by: [Signature] JFC	Preliminary Approval:
Date: 15/02/11 9-89	Date: 2005-02-13	Date:

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	
C	13.05.27	Dimensions revised per Dwg Rev D	KJ [Signature]	AA

ITEM	QTY	P/N	DESCRIPTION
	X	D3179-041	LITTER TIE DOWN BRACKET
1	2	D2372	QUICK RELEASE
2	1	D2444	PIP PIN
3	1	D3179-1	LITTER TIE DOWN BRACKET
4	1	MS21042L3	NUT
5	1	MS27039-1-13	SCREW
6	3	NAS1149D0332J	WASHER (AN960JD10L)



D3179-041 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3179-041" ON BOTTOM FACE USING FINE POINT PERMANENT INK MARKER AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.79 lbs

COPY
SUBMIT

128847 MJS
15-01-29

RELEASED
2013-05-16

D	POSITION AND SHAPE OF LITTER CAPTURE SLOTS CHANGED (ZN B4-2, B8-2, C7-2); ADD ENGRAVING NOTE (ZN C4-2); REF CIR13-15	DB	13.03.22
C	ADD D3179-041 & PARTS LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N	RF	08.11.07
B	REFORMAT DRAWING, FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/1	D3179	SHEET 1 OF 2
APPROVED	1/2	TITLE	SCALE
DE APPR.	H	LITTER TIE DOWN BRACKET	NTS
DATE	13.03.22	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

